



Dart Aerospace Ltd.
1270 Aberdeen St
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Canada

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D4776-3

Job Sheet 192839



Part No: D4776-3

Job Qty: 30 pcs

Part Name: Skidtube Clevis



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 4/2/19

Job Tracking No:

Created By: Shannon Hadley

Due Date: 4/22/19

Type: SOLD

Description:

Note: DWG D4776 REV.E IPP REV A: NEW ISSUE JFS 13/03/07 VERIFY BY: JLM IPP REV:B 13.09.26 AS PER REV.B DD VERF:JLM IPP REV:C AS PER REV. PC1 JFS 13/11/07 VERIFY BY: JLM

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
100	Bandsaw - 1	30 pcs		4/22/19	0.00	0.54	Bandsaw - 1		mm
110	HAAS 4 Axis - B4B	30 pcs		4/22/19	0.26	26.09	HAAS - 1 - B4B		
							HAAS - 2 - B4B		
							HAAS - 3 - B4B		
							HAAS - 4 - B4B		mm 2019/05/08
120	QC 2	30 pcs		4/22/19	0.00	0.00	QC 2 - 1		
							QC 2 - 12		
							QC 2 - 14		
							QC 2 - 17		
							QC 2 - 19		
							QC 2 - 2		
							QC 2 - 20		
							QC 2 - 22		
							QC 2 - 23		
							QC 2 - 25		
							QC 2 - 32		
							QC 2 - 33		
							QC 2 - 35		
							QC 2 - 39		
							QC 2 - 4		
							QC 2 - 40		
							QC 2 - 44		
							QC 2 - 45		
							QC 2 - 48		
							QC 2 - 49		
							QC 2 - 50		
							QC 2 - 51		
							QC 2 - 52		
							QC 2 - 56		
							QC 2 - 57		

DART
AEROSPACE

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1270 Burdett Street
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CANADA
TEL: 513 832-8200
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Container No: S178857



Part: D4776-3

Job No: 192839

Serial No/Batch: S178857

Revision: E

Inspector:

Exp Date:

Instructions: Various STC's

Date: 05/08/19

				QC 2 - 62	
				QC 2 - 63	
				QC 2 - 8	
				QC 2 - 66	
				QC 2 - 64	mm. 2019/05 /08
				QC 2 - 65	
				QC 2 - 5	
130 QC 8	30 pcs	4/22/19	0.00 0.00	QC 8 - 12	
				QC 8 - 14	mm. 2019/05/08
				QC 8 - 17	
				QC 8 - 20	
				QC 8 - 25	
				QC 8 - 3	
				QC 8 - 32	
				QC 8 - 33	
				QC 8 - 35	
				QC 8 - 39	
				QC 8 - 4	
				QC 8 - 44	
				QC 8 - 45	
				QC 8 - 49	
				QC 8 - 58	
				QC 8 - 8	
				QC 8 - 9	
				QC 8 - 68	
				QC 8 - 67	
				QC 8 - 1 (A)	
				QC 8 - 47	
				QC 8 - 40	
				QC 8 - 52	
				QC 8 - 23	
140 Handfinish - 1-1 Chemical-B4B	30 pcs	4/22/19	0.00 0.79	Handfinish - 1 - 1 - B4B	BEB 19-05-08
				Handfinish - 1 - 2 - B4B	
				Handfinish - 1 - 3 - B4B	
				Handfinish - 1 - 4 - B4B	
				Handfinish - 1 - 5 - B4B	
				Handfinish - 1 - 6 - B4B	
				Handfinish - 1 - 7 - B4B	
				Handfinish - 1 - 8 - B4B	
				Handfinish - 1 - 9 - B4B	
				Handfinish - 1 - 10 - B4B	
				Handfinish - 1 - 11 - B4B	
				Handfinish - 1 - 12 - B4B	
				Handfinish - 1 - 13 - B4B	
				Handfinish - 1 - 14 - B4B	
				Handfinish - 1 - 15 - B4B	
				Handfinish - 1 - 16 -	

150	QC 7	30 pcs	4/22/19	0.00	0.00	B4B	Handfinish - 1 - 17 - B4B
							Handfinish - 1 - 18 - B4B
							Handfinish - 1 - 19 - B4B
							Handfinish - 1 - 20 - B4B
							Handfinish - 1 - 21 - B4B
							Handfinish - 1 - 22 - B4B
							QC 7 - 10
							QC 7 - 13
							QC 7 - 14
							QC 7 - 15
							QC 7 - 17
							QC 7 - 18
							QC 7 - 19
							QC 7 - 2
							QC 7 - 28
							QC 7 - 3
							QC 7 - 30
							QC 7 - 34
							QC 7 - 36
							QC 7 - 37
							QC 7 - 41
							QC 7 - 47
							QC 7 - 48
							QC 7 - 51
							QC 7 - 58
							QC 7 - 59
							QC 7 - 60
							QC 7 - 9
							QC 7 - 68
							QC 7 - 50
							QC 7 - 67
							QC 7 - 40
							Powdercoat - 1 - B4B
							Powdercoat - 2 - B4B
							Powdercoat - 3 - B4B
							Powdercoat - 4 - B4B
							QC 3 - 10
							QC 3 - 13
							QC 3 - 15
							QC 3 - 17
							QC 3 - 18
							QC 3 - 2
							QC 3 - 28
							QC 3 - 3
							QC 3 - 30
							QC 3 - 34
							QC 3 - 36
							QC 3 - 41
							QC 3 - 51
							QC 3 - 58
							QC 3 - 59
							QC 3 - 68
							QC 3 - 9

MAY 10 2019

40

9-89

				QC 3 - 40			
				QC 3 - 19			
180	Packaging 3-1 - Stock - B4B	30 pcs	4/22/19	0.00	0.00	Packaging 3 - 1 - B4B	
						Packaging 3 - 2 - B4B	
						Packaging 3 - 3 - B4B	
						Packaging 3 - 4 - B4B	ST 115 90 , MAY 10 2019
						Packaging 3 - 5 - B4B	
						Packaging 3 - 6 - B4B	
						Packaging 3 - 7 - B4B	
						Packaging 3 - 8 - B4B	
						Packaging 3 - 9 - B4B	
						Packaging 3 - 10 - B4B	
						Packaging 3 - 11 - B4B	
						Packaging 3 - 12 - B4B	
						Packaging 3 - 13 - B4B	
						Packaging 3 - 14 - B4B	
						Packaging 3 - 15 - B4B	
						Packaging 3 - 16 - B4B	
						Packaging 3 - 17 - B4B	
						Packaging 3 - 18 - B4B	
						Packaging 3 - 19 - B4B	
						Packaging 3 - 20 - B4B	
						Packaging 3 - 21 - B4B	
						Packaging 3 - 22 - B4B	
						Packaging 3 - 23 - B4B	
						Packaging 3 - 24 - B4B	
						Packaging 3 - 25 - B4B	
						Packaging 3 - 26 - B4B	
						Packaging 3 - 27 - B4B	
						Packaging 3 - 28 - B4B	
						Packaging 3 - 29 - B4B	
						Packaging 3 - 30 - B4B	
						Packaging 3 - 31 - B4B	
						Packaging 3 - 32 - B4B	
						Packaging 3 - 33 - B4B	
						Packaging 3 - 34 - B4B	
						Packaging 3 - 35 - B4B	
						Packaging 3 - 36 -	

				B4B	
190 QC 21 - SA	30 pcs	4/22/19	0.00	0.00	QC 21 - SA - 21
					QC 21 - SA - 70
					QC 21 - SA - 53
Part Op 100 - Cut Blank at 4.625" Descriptions: 110 - 1-Machine per folio FB168 DWG REV: _____ FOLIO REV: _____ 2- deburr and break all sharp edges 120 - (QC2- Inspect parts off machine FAI/FAIB) 130 - (QC8- Inspect parts - second check) 140 - (Chemical Conversion Coat per QSI005 4.1) 150 - (QC7-Inspect Chemical Conversion Coat) 160 - (White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum) START TIME: _____ OVEN TEMPERATURE: _____ FINISH TIME: _____ 170 - (QC3- Inspect Part Finish) 180 - (Identify as per dwg & Stock Location: _____) 190 - (QC21- Final Inspection - Work Order Release)					
Job BOM					
Part / Item	Component Name	Quantity	Operation	Container	
M6061T6B1.500X2.500	6061-T6 Bar 1.50 X 2.50	11.5800 ft (.386 ea)	100-Bandsaw - 1	① - 5052919 x18-7.006	
				② - 5166894 x12-4.671	
Job Allocations					
Operation	Component Part	Required	Inventory	Allocated	
100-Bandsaw - 1	M6061T6B1.500X2.500	12	69	0	

MAT
USED

Part Specifications					
Spec No	Description	Target/Tolerance	Limits	Type	Special Comments
1	Skidtube Clevis	4.430inches $\pm$ 0.030	4.460 4.400	1.430	
2	Skidtube Clevis	2.300inches $\pm$ 0.030	2.330 2.270	2.300	
3	Skidtube Clevis	1.778inches $\pm$ 0.010	1.788 1.768	1.777	
4	Skidtube Clevis	0.880Inches $\pm$ 0.030	0.910 0.850	0.878	
5	Skidtube Clevis	0.510Inches + 0.010 - 0.000	0.520 0.510	0.511	
6	Skidtube Clevis	1.063Inches $\pm$ 0.010	1.073 1.053	1.065	
7	Skidtube Clevis	1.380Inches $\pm$ 0.030	1.410 1.350	1.380	
8	Skidtube Clevis	0.190Inches $\pm$ 0.030	0.220 0.160	0.190	
9	Skidtube Clevis	0.100inches $\pm$ 0.010	0.110 0.090	0.100	
10	Skidtube Clevis	0.484Inches + 0.006 - 0.001	0.490 0.483	0.486	Diameter
11	Skidtube Clevis	0.500Inches $\pm$ 0.030	0.530 0.470	0.501	
12	Skidtube Clevis	0.640inches $\pm$ 0.030	0.670 0.610	0.643	
13	Skidtube Clevis	3.150Inches $\pm$ 0.010	3.160 3.140	3.150	
14	Skidtube Clevis	1.080inches $\pm$ 0.010	1.090 1.070	1.080	
15	Skidtube Clevis	0.688Inches $\pm$ 0.010	0.698 0.678	0.687	
16	Skidtube Clevis	0.397Inches + 0.006 - 0.001	0.403 0.396	0.398	Diameter
17	Skidtube Clevis	1.863inches $\pm$ 0.010	1.873 1.853	1.864	
18	Skidtube Clevis	0.190Inches $\pm$ 0.030	0.220 0.160	0.190	Radius
19	Skidtube Clevis	0.130Inches $\pm$ 0.030	0.160 0.100	0.130	Radius
20	Skidtube Clevis	0.440Inches $\pm$ 0.030	0.470 0.410	0.440	Radius
21	Skidtube Clevis	0.125Inches $\pm$ 0.010	0.135 0.115	0.125	
24	Skidtube Clevis	0.250Inches $\pm$ 0.030	0.280 0.220	0.250	Radius
25	Skidtube Clevis	1.050inches $\pm$ 0.030	1.080 1.020	1.050	Product
26	Skidtube Clevis	1.430 $\pm$ 0.030		1.430	
27	Skidtube Clevis	1.130inches $\pm$ 0.030	1.160 1.100	1.129	Product
28	Skidtube Clevis	0.060 $\pm$ 0.030		0.060	Product
29	Skidtube Clevis	0.810inches $\pm$ 0.030	0.840 0.780	0.810	Product
30	Skidtube Clevis	0.060 $\pm$ 0.030		0.060	Product
31	Skidtube Clevis	0.183inches $\pm$ 0.010	0.193 0.173	0.183	Product

Entered: _____ Date: _____



WORK ORDER NON-CONFORMANCE / ROUTE UPDATE

NCR No. _____

Route update only ☐

Job: _____ Part No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐	DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Eng. (Non-AW) ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Engineering ☐ Water Jet ☐ Supplier ☐ Quality ☐			
Date :	Sequence #:	QTY Affected :		MRB (QSI042)	
Description Work Order Deviation		Disposition		Completed By	
				Lead hand / Supervisor	
				QC / QA Coordinator	
Root Cause Operator ☐ Manufacturing Process ☐ Equip/Tooling ☐ Handling/Preservation ☐ Material ☐ Product Improvement ☐ Process Improvement ☐ Human Factors ☐		FAULT CATEGORY ☐ Pressure/Forced ☐ Bending ☐ Crushing ☐ Cracks ☐ Crimp/Kink/Ripple/Wave/Twist ☐ Marks/Chatter ☐ Mislabeled ☐ Contamination ☐ Misaligned/off center ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Incomplete/Unclear Instructions ☐ Drill Holes ☐ Fit/Function ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain Direction ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set/Set-up ☐ Positioned Wrong ☐ Outside Tolerance ☐ Drawing ☐ Finish ☐ Part Lost/Missing ☐ Misread			
Other/Details:					



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D4776-3**Job Sheet 192784****Part No:** D4776-3**Job Qty:** 30 ea**Part Name:** Skidtube Clevis**Part Weight:** 0 lbs**Status:** New**Priority:** Medium**Job Created:** 4/2/19**Job Tracking No:****Due Date:** 4/22/19**Created By:** Marie Lajeunesse**Type:** SOLD**Description:**

Note: DWG D4776 REV:E IPP REV A: NEW ISSUE JFS 13/03/07 VERIFY BY: JLM IPP REV:B 13.09.26 AS PER REV.B DD VERF:JLM IPP REV:C AS PER REV. PC1 JFS 13/11/07 VERIFY BY: JLM

Ship Via:**Bill of Materials****Job Routing**

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
100	Bandsaw - 1	30 pcs	4/22/19	4/22/19	0.00	0.54	Bandsaw - 1		
110	CNC Vertical Machining	30 pcs	4/22/19	4/22/19	0.26	26.09	HAAS1-5		
120	QC	30 pcs	4/22/19	4/22/19	0.00	0.00	QC2 Machining-3		
130	QC	30 pcs	4/22/19	4/22/19	0.00	0.00	QC8 Machining-3		
140	HandFinish	30 pcs	4/22/19	4/22/19	0.00	0.79	HandFinish1		
150	QC	30 pcs	4/22/19	4/22/19	0.00	0.00	QC7-4		
160	Powdercoat	30 pcs	4/22/19	4/22/19	0.00	0.37	Powdercoat1		
170	QC	30 pcs	4/22/19	4/22/19	0.00	0.00	QC3		
180	Packaging	30 pcs	4/22/19	4/22/19	0.00	0.00	Packaging3-2		
190	QC21-SA	30 Ea	4/22/19	4/22/19	0.00	0.00	QC21		

Part Op 100 - Cut Blank at 4.625"

Descriptions: 110 - 1-Machine per folio FB168 DWG REV: _____ FOLIO REV: _____ 2- deburr and break all sharp edges

160 - START TIME: _____ OVEN TEMPERATURE: _____ FINISH TIME: _____

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
M6061T6B1.500X2.500	6061-T6 Bar 1.50 X 2.50	11.5800 ft (.386 ea)	100-Bandsaw - 1	

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
100-Bandsaw - 1	M6061T6B1.500X2.500	12	69	0